

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.12**DAILY PROJECT JOURNAL****Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Report No:** DPJ-000333**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Dated:** 04-Oct-2007**Location:** Changxing Island, Shanghai, China

Submittals(New / Total): **CWR's:** 0 / 4 **HSR's:** 0 / 3 **NCR's:** 1 / 10

Item	Title	Detail
1	Nonconformance Reports (NCRs)	NCR-011 QC failure to mark inspection performed on part
2	Major component movement	<p>77m Tower Mock-up: Installing Connection Plates on Skin Plates.</p> <p>89m Tower Mock-up: No welding observed.</p> <p>114m Tower Mock-up: Performing weld repairs to Skin Plate Stiffeners, Welding of interior connection plates on Skin Plates.</p>
3	Meetings attended	<p>QA met with ABF and ZPMC at 1400 to discuss the schedule for the next two days: Bending of flange plates at Wuxi Boiler for the 77m and 89m Tower Mock-ups is scheduled for Saturday, October 6, 2007. RT for Non-Standard joint qualifications to take place in Shanghai on Saturday, October 6, 2007.</p> <p>77m Tower Mock-up: Skin A awaiting CWR for 3rd time repair, Installing Connection Plates on Skin Plate D Diaphragms pending new flange plates from Wuxi Boiler.</p> <p>89m Tower Mock-up: Beveling Skin Plates A, B, D and E Diaphragms pending new flange plates from Wuxi Boiler.</p> <p>114m Tower Mock-up: Perform NDT and repairs to Skin Plate Stiffeners.</p>
4	Key conversations	<p>Caltrans met with ABF and ZPMC at 1300 to discuss issues related to fabrication: Caltrans, ABF and ZPMC discussed the amount of rejections seen on the 77m and 114m Tower Mock-ups. ABF stated that of the 50 stiffeners welded only 2 did not have rejections (this figure is worse than QA</p>

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estimates), and that ZPMC cannot continue welding with these rates. ABF stated they would require ZPMC to demonstrate that they can perform satisfactory stiffener to plate weld before they will be allowed to continue fabrication. ABF is not convinced that the new welders are significantly better than current welders, and ABF is requesting proof of improvement prior to allowing ZPMC to proceed. ZPMC has considered performing the stiffener to skin weld an inclined position to make the weld position flat, but does not know how to maintain flatness of the member. ZPMC requested guidance from Caltrans and ABF.

ABF asked ZPMC why they were welding new stiffeners after ABF gave written notification that no new welds be performed. ZPMC did not respond in Caltrans presence.

5	Other important observations	Caltrans met with ABF and ZPMC to discuss issues raised by Caltrans. Discussed were the repair rate on the Tower Mock-ups, Closed-rib Weld Trials, Closed-rib UT Procedure and OBG Bottom and Side Plate Fabrication.
6	Quality Assurance Inspectors per shift	3 Day Shift (Acuna, Franco, Viars) 3 Swing Shift (Berger, Dixon, Smith) 0 Graveyard Shift
7	Logistics	ZPMC informed QA that they would not be welding during night shift tonight.

Inspected By: McClary, David

Quality Assurance Inspector

Reviewed By: Lowry, Patrick

QA Reviewer
